

Work Order ID 150297

Wednesday, August 24, 2016 11:38:14 AM

150297

Page 1

Item ID: D412-630-032

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: **DAS 21** Date: **AUG 26 2016**

Tooling:

Date:

Run Start

NR1QC: **9-89**

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						21		
D3462	REV C						9-89		
IIN D412-630	O	NOV 01 2016							

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004

1X

DAS 28
9-89**NOV 23 2016**

110

Small Fab

0.00

110

Small Fab

Memo

0.04

Small Fab

Assemble as per IIN D412-630

1X

DAS 36
9-89
16/11/13

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch:

1131371

DQA:

Date: 2017-02-22



QA Closed:

Date:

JAN 20 2017

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: 150297		DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Part No. P412-630-032		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
NCR No.		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☒	Other ☐
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐	
Date: 16-11-01		Step #: 120 110		QTY Effective: ①		MRB (QSI042) Approval DAS 9 9-89 16-11-01	
Description Work Order Deviation				Disposition			
found during assembly that step weldment had some scratch in the point. R.C. handling. Parts are not protected from point damage will in storage				scuff D3463-042 and re powder coat M 134798 START: 12:50 OV: T: 320° FINISH: 1:20. Apply new wing walk. M 135819			
				Completed By ① 16-11-01 BEB 16-11-01 Lead hand / Supervisor Approval Verification DAS 38 9-89 NOV 03 2016			
				QC / QA Coordinator Approval DAS 9 9-89 16-12-05			
Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	☒ Broken/Damage/Defect	Weld ☐	Part Incorrect ☐		
Handling/Pre ☒	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER :					

Work Order ID 150297

Wednesday, August 24, 2016 11:38:14 AM

150297

Page 2

Item ID: D412-630-032 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear
Start Date: 8/16/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo ****ensure tension to retract step is 11 to 18 lbs **** Test fit on aircraft in Eng. lab. ENSURE STEP IS A LH: _____	0.00 0.00				1			DAS 38 9-89 NOV 03 2016
130 *130* Packaging Packaging	Pick Kit Memo	0.00 0.00				1X			DAS 27 9-89
140 *140* QC Quality Control	QC4- 100% Inspect kits for completeness Memo VERIFY ORIENTATION OF D3462/D3463: _____	0.00 0.00				1X			DAS 28 9-89 NOV 23 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐	☐				

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Page 3

Item ID: D412-630-032 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
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Start Date: 8/16/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/1/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00				DAS 28 9-89		DAS 27 9-89	NOV 23 2016
150	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-032								
Packaging	ENSURE STERIS A RH: _____								
	Location: FG034								
160	QC21- Final Inspection - Work Order Release	0.00				DAS 21 9-89			NOV 23 2016
160	Memo	0.02							
QC									
Quality Control									

DAS
21
9-89

NOV 23 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
0AD 8S 00-0				0AD 8S 00-0				Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐						Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐													
OTHER :																									

Picklist Print

Wednesday, August 24, 2016 11:38:12 AM

Page 1

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
removed qty 1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER
IIN REV: O DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 *AN310-4* Nut		Purchased	No			130	Each	175.0000	1 **	1 135764		DAS 6 9-89	DAS 27 9-89

Location	Loc Qty	Loc Code
GA	25	
M127815	25	
OVER007	100	
M135442	100	
ST331	50	
M134955	50	

AN310-4 *AN310-4* Nut		Purchased	No			110	Each	175.0000	1 **	1 NOV 01 2016		DAS 6 9-89	
------------------------------------	--	-----------	----	--	--	-----	------	----------	---------	------------------	--	------------------	--

Location	Loc Qty	Loc Code
GA	25	
M127815	25	
OVER007	100	
M135442	100	
ST331	50	
M134955	50	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Description Work Order Deviation				Disposition																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 2

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

AN310-5 Purchased No 130 Each 25.0000

AN310-5

Nut

2 2

**

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST331

25

m129706

9

m131320

16

AN310-7 Purchased No 110 Each 65.0000

AN310-7

Nut

1 1

**

NOV 0 1 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST331

65

124198

25

m120124

40

AN3C5A Purchased No 130 Each 1,639.000

AN3C5A

Bolt

3 3

**

NOV 0 3 2016

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

11

M134502

11

OVER002

1350

M134955

300

M135297

600

M135442

200

M135470

250

ST350

273

M133234

1

M134676

272

3

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : _____					

Picklist Print

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Page 3

Work Order ID: 150297

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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

AN44-C12

Purchased

No

130

Each

12.0000

1 1

AN44-C12

Eye Bolt

**

135885

NOV 03 2016

DAS 27
6 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

FG

3

124829

3

ST339

9

M132879

4

M135297

5

AN4C14

Purchased

No

110

Each

32.0000

1 1

AN4C14

Bolt

**

135704

NOV 01 2016

DAS 6
9-89

Location

Loc Qty

Loc Code

ST344

32

m131264

2

m135084

30

AN4C15

Purchased

No

130

Each

31.0000

1 1

AN4C15

Bolt

**

135665 135704

NOV 03 2016

DAS 27
6 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

over003

15

M135046

15

ST343

16

M1134567

16

AN4CH3

Purchased

No

110

Each

83.0000

2 2

AN4CH3

Bolt

**

135665

NOV 01 2016

DAS 6
9-89

Location

Loc Qty

Loc Code

ST346

83

M132124

8

M135482

75

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

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Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				240 05 234	
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Wednesday, August 24, 2016 11:38:13 AM

Page 4

Work Order ID: 150297

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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

AN5C11 Purchased No 130 Each 11.0000 1 1
AN5C11
 BOLT

**

135722

DAS 27
 6 9-89

Location Loc Qty Loc Code

ST338 11
 M134887 11

NOV 03 2016

AN5C15 Purchased No 130 Each 14.0000 1 1
AN5C15
 BOLT

**

135704

68-6
 9 DAS 27
 6 9-89

Location Loc Qty Loc Code

ST337 14
 M132317 4
 M135297 10

NOV 03 2016
 NOV 01 2016

D3443-041 Manufactured No 110 Each 1.0000 1 1
D3443-041
 Strut Weldment Assembly

**

NOV 01 2016

DAS 6
 6 9-89

Location Loc Qty Loc Code

ST525 1
 144279 1

D3443-043 Manufactured No 110 Each 1.0000 1 1
D3443-043
 Strut Weldment Assembly

**

NOV 01 2016

DAS 6
 6 9-89

Location Loc Qty Loc Code

ST525 1
 145453 1

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 4

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 5

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3443-9

Manufactured No

110

Each

115.0000

2

2

D3443-9

Pin

**

NOV 0 1 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST037

115

145541

14

149322

101

D3454-1

Manufactured No

130

Each

58.0000

1

1

D3454-1

Bushing

**

NOV 0 3 2016

DAS
6
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

58

146027

10

149447

48

D3454-3

Manufactured No

130

Each

123.0000

2

2

D3454-3

Bushing

**

NOV 0 3 2016

DAS
6
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

123

121223

22

149416

101

D3454-5

Manufactured No

130

Each

117.0000

2

2

D3454-5

Bushing

**

NOV 0 3 2016

DAS
6
9-89
DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

13

148239

13

ST038A

104

145571

3

149326

101

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐					
OTHER : _____									

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 6

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3454-7

Manufactured No

110

Each

124.0000

2

2

D3454-7

Bushing

**

NOV 01 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST037

22

144631

22

ST038A

102

149466

102

D3455-1

Manufactured No

110

Each

373.0000

2

2

D3455-1

Spacer

**

NOV 01 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST037

66

147371

66

ST038A

307

149364

307

D3455-1

Manufactured No

130

Each

373.0000

4

4

D3455-1

Spacer

**

NOV 01 2016

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

66

147371

66

ST038A

307

149364

307

D3455-3

Manufactured No

130

Each

95.0000

2

2

D3455-3

Spacer

**

NOV 03 2016

DAS
6
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

95

146067

11

149459

84

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 6

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date: 07-03		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
3rd 8 12-0								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Set-up ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :			
Misidentified ☐	Past Due ☐																																																																

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 7

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

D3462-042

Manufactured No

130 Each

2.0000

1 1

D3462-042

Bracket Assembly

**

NOV 03 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST038

2

146512

2

D3463-042

Manufactured No

110 Each

2.0000

1 1

D3463-042

Step Weldment Assembly

**

NOV 01 2016

DAS 6
9-89

Location

Loc Qty

Loc Code

ST386

2

144282

2

D3465-1

Manufactured No

110 Each

52.0000

1 1

D3465-1

Washer

**

149365

NOV 01 2016

DAS 6
9-89

Location

Loc Qty

Loc Code

ST038

52

149356

52

D3672-5

Manufactured No

130 Each

622.0000

1 1

D3672-5

Washer, Phenolic

**

NOV 03 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

FG

8

44679

8

ST049

234

35521

234

ST051A

380

50354

380

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By _____					
				Lead hand / Supervisor Approval Verification _____					
				QC / QA Coordinator Approval _____					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 8

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

130

Each

978.0000

3

3

MS21043-3

Nut

**

135704

DAS

27

DAS

6

9-89

9-89

NOV 03 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

80

103691

80

FP001

11

m130673

11

GA

237

m133990

237

OVER007

400

m134861

0

m135442

400

ST302

181

m135058

181

ST304

69

m131340

69

MS24665-227

Purchased

No

110

Each

105.0000

1

1

MS24665-227

Cotter Pin

**

135671

NOV 01 2016

DAS

6

9-89

Location

Loc Qty

Loc Code

GA

16

111041

16

ST289

89

m127831

89

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 8

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date : _____		Step #: _____		QTY Effective : _____				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval			
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐									
		OTHER : _____									

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 9

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

MS24665-227

Purchased

No

130

Each

105.0000

1

1

MS24665-227

Cotter Pin

**

135671

NOV 03 2016

DAS 6 27
9-89 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

GA

16

111041

16

ST289

89

m127831

89

MS24665-229

Purchased

No

130

Each

71.0000

2

2

MS24665-229

Cotter Pin

**

135671

NOV 03 2016

DAS 6 27
9-89 9-89

DAS 28
9-89

Location

Loc Qty

Loc Code

GA

5

118234

5

ST289

66

m132123

66

MS24665-302

Purchased

No

110

Each

29.0000

1

1

MS24665-302

Cotter Pin

**

135672

NOV 01 2016

DAS 6
9-89

Location

Loc Qty

Loc Code

GA

15

120521

15

ST288

14

m134738

14

Wednesday, August 24, 2016 11:38:13 AM

Shop Packet Print

Page 9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Wednesday, August 24, 2016 11:38:13 AM

Page 10

Work Order ID: 150297

150297

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016

Required Date: 9/1/2016

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0363R

Purchased

No

130

Each

478.0000

7

7

NAS1149C0363R

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

265

114742

6

m133077

259

GA

213

m133077

213

NAS1149C0563R

Purchased

No

130

Each

446.0000

1

1

NAS1149C0563R

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

ST265

446

m131697

446

**

135445

NOV 03 2016

DAS
27
6
9-89

**

NOV 03 2016

DAS
27
6
9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

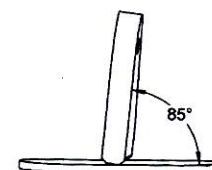
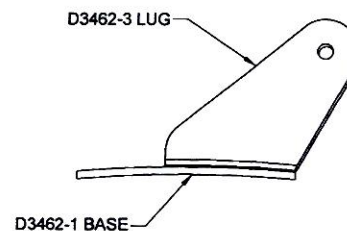
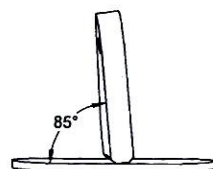
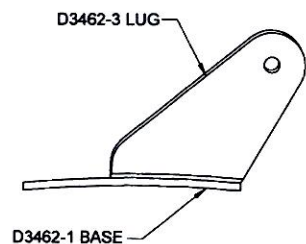
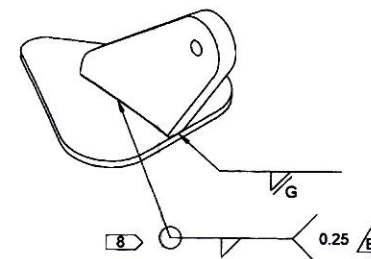
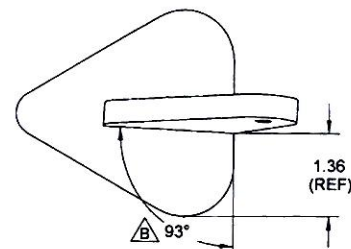
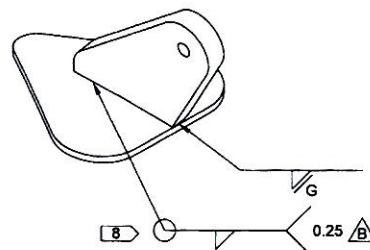
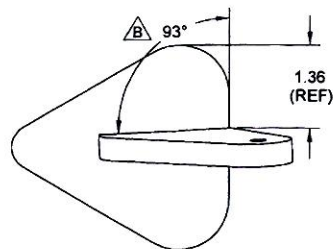


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

STOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 150297 M.C.S
1608-26

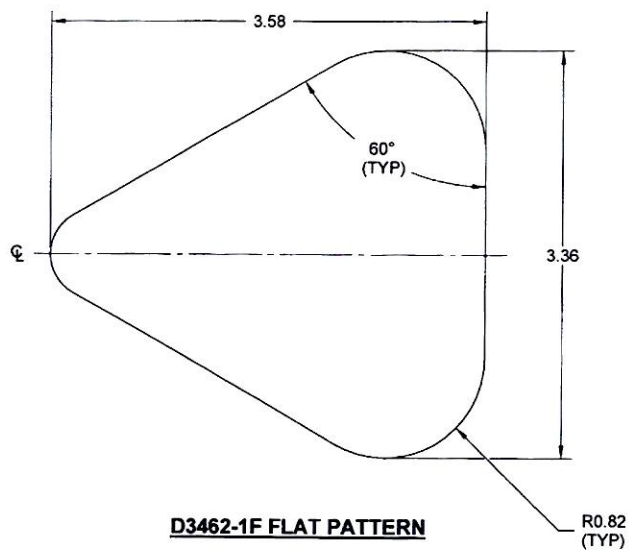
C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		

RELEASED
060701 1/20

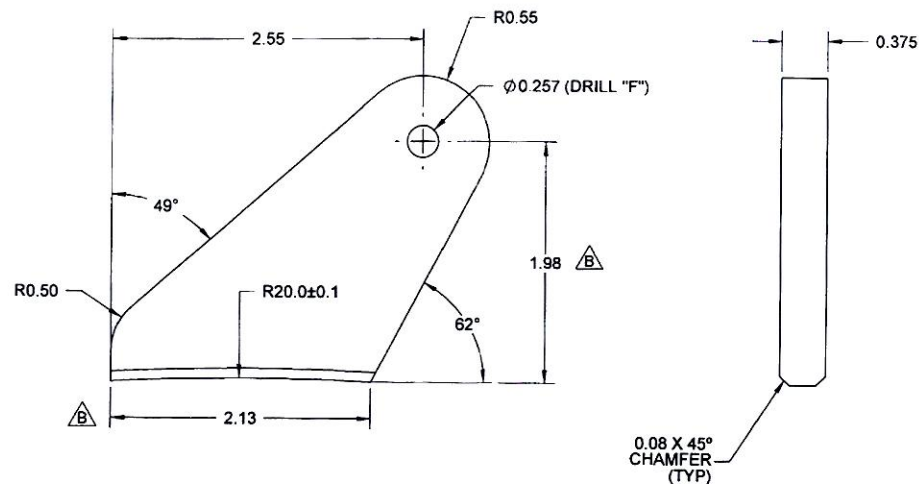
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3462
REV. C
SHEET 1 OF 2
TITLE
BRACKET ASSEMBLY
SCALE
1:2

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- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:**
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
8-27-01

DESIGN	1F	DART AEROSPACE LTD	
DRAWN	1F	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1F	DRAWING NO.	REV. C
MFG. APPR.	1F	D3462	SHEET 2 OF 2
APPROVED	1F	TITLE	SCALE
DE APPR.	1F	BRACKET ASSEMBLY	1:1
DATE	07.10.24	COPYRIGHT © 2005 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Work Order ID 150297***150297***

Page 1

Tuesday, November 01, 2016 8:33:55 AM

Item ID: D412-630-032

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear

Start Date: 8/16/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/1/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3462	REV C
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IIN D412-630	O
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100	Document Control	0.00
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100	DOCUMENT CONTROL	
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DC	Memo	0.00
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Doc.Control -USB or Paperwork	Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004	
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DAS
21
9-39

NOV 01 2016

110		0.00
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110	Small Fab	
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Small Fab	Memo	0.04
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Small Fab	Assemble as per IIN D412-630	
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****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch: _____

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
1	1	D3672-5	WASHER (OR NAS1515H5)
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
2	2	AN3C5A	BOLT
1	1	AN3C6A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	NAS1149C0363R	WASHER (OR AN960C10)
1	1	NAS1149C0563R	WASHER (OR AN960C516)
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP.
SEE FIGURE 13B (D412-630-023/-024 KITS) OR FIGURE 16B (D412-630-033/-034 KITS).